












Date: Monday, 8/13/2007 10:02:03 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 33875	
Estimate Number : 12681	
P.O. Number : <i>N/A</i>	Part Number : D3594043
This Issue : 8/13/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3594 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33551	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/20/2007 Qty: 30 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
			
Comment: Qty.: 0.5355 sf(s)/Unit Total : 16.0650 sf(s) 6061-T6 .080 Sheet Batch: <i>M104921</i> <i>SAC 07/08/13</i>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> 2-Deburr if necessary <i>SAC 07/08/13 30</i>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAC 07/08/13 30</i>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <i>Er 07/08/13 +30</i> <i>carter</i>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS PER DWG D3594 <i>MF 07-08-16</i> <i>(30)</i>			

POSITIVE
RECALL

Date: Monday, 8/13/2007 10:02:03 AM
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Seq. #: Machine Or Operation: Description:

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

canco
on 07/08/03 (430)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

25

07-08-25

(30)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-08-28

9.0 MS210695 Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Anchor nuts

BATCH: M104214 x4mx

M105513 (25x)

M105889 (5x)

07/10/31

10.0 MS20426AD44 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Rivet

BATCH: M1021

07/10/31

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

07/10/31 (30)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

canco
on 07/10/06 (430)

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C7/11/08 (30)

POSITIVE RECALL

EFFECTIVE 07/08/02 AUTH W

RELEASED 07/08/23

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

17.11.08

Job Completion



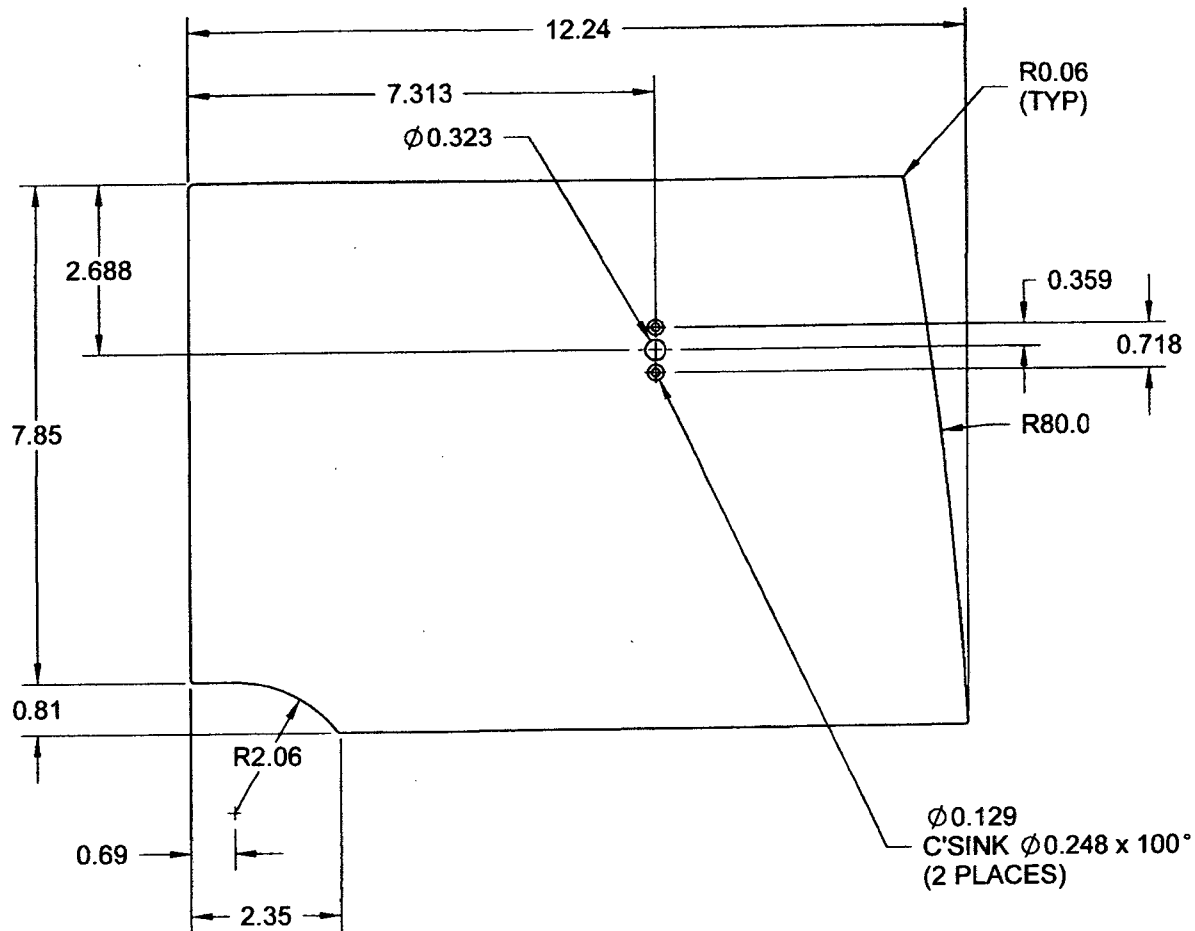
U 17.11.08



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

RELEASED
07.07.11 13

Per 66141001



D3594-3 FLOOR DOUBLER
(D3594-4 OPPOSITE)

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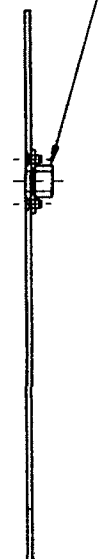
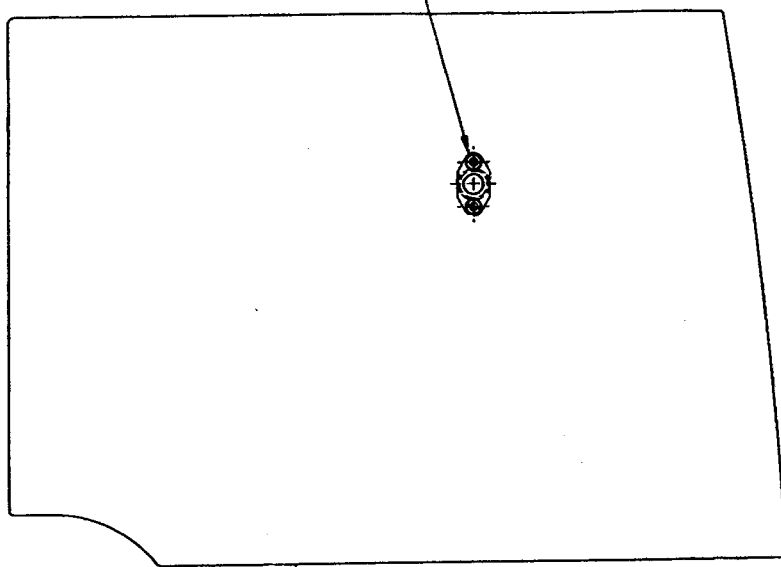
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3594	REV. A SHEET 2 OF 3
DATE 07.04.13		TITLE FLOOR DOUBLER ASSEMBLY SCALE 1:3	

RELEASED
07.07.11

P82 600 #1007

MS20426AD4-4 RIVET
(2 PLACES)MS21069-5
ANCHOR NUTD3594-3 FLOOR DOUBLER (D3594-043)
D3594-4 FLOOR DOUBLER (D3594-044)**D3594-043 FLOOR DOUBLER ASSEMBLY**
(D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

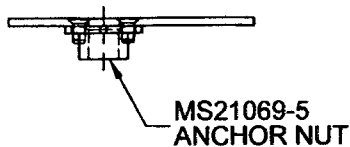
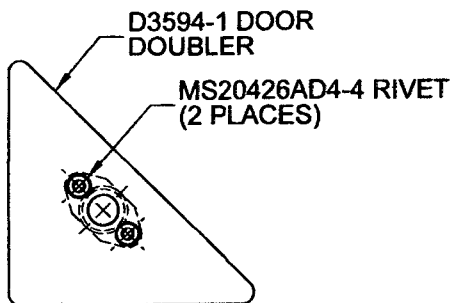
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

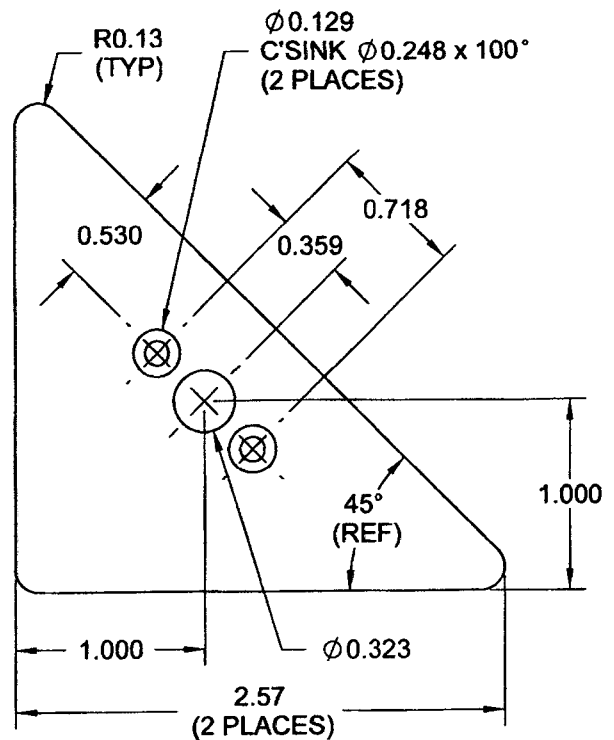
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DART**RELEASED**
07.07.11
Per [signature]

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 1 OF 3
DATE 07.04.13	TITLE DOUBLER		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**
SCALE 1:2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/22	#5.0	2 parts has 1 hole (each) that was countersunk too deep RC Hummer error	GS/04/22	mat. is 6061-T6. Fill hole with weld per AS204 and grind flush sk	MF 07-08-22	En 07/08/22	GS/04/22	En 07/08/22
			↓	using MS 21065-5 Aut plate. Transfer drill hole and re-countersink	MF 07-08-22	↓	↓	↓

NOTE: Date & initial all entries